Work Order ID 79387 *79387* Page 1 January-25-12 11:51:33 AM D212-664-207 Item ID: Accept *N900040100* Setup Start **Revision ID: Item Name:** Crosstube Low Standard Aft **Start Date:** 25/01/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 08/02/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Approvals: Process Plan: _M.し.丁 Date: 12/61/25 Tooling: Date: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description Run Hours Qty Code Qty Number Stamp **Draw Nbr Revision Nbr** D212-664-247 Rev B (DEO) 100 0.00 DOCUMENT CONTROL *100* DC Memo Document Control Photocopy bluefile and create labels as per PPP D212-664-207 CHG002 110 Pick Kit 0.00 Packaging *110* Packaging 0.00 Memo Packaging 120 0.00 BENDING MACHINE - CROSSTUBES *120* CNC Bend 2 0.00 Memo CNC Alpha 160 Bender Bend tube as per Dwg D212-664-247 using CNC bender program · and Folio

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W/O:			WORK ORDER CHANGES								
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Part No		PAR #:									
	Resolution:							Date:			
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DATE	STEP	Description of NC			tion B	Verific	ation	Approval	Approval		
	O I E I	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	on C	Chief,Eng	QC Inspector		
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Work Order ID 79387

January-25-12	11:51:33 AM	1			~ / <u>9</u>	387°						Page 2
Item ID: Revision ID:	D212-664-2	207			Accept	*N900	040	100)*	Setup Sta	rt *N	S1*
Item Name:	Crosstube Lo	w Standard Aft								Sto	^{op} *N	S2*
Start Date:	25/01/2012	Start Qty: 1.00		*1*		Cust Item 1	ID:					
Required Date	: 08/02/2012	Req'd Qty: 1.00		*1*		Customer:						
Reference:					•							
Approvals:	Process Pla	an:	_ Date:		Tooling:	D	ate:		•	Run Sta	1/1	R1*
	QC:		_ Date:		_ SPC (Y/N):	D:	ate:			Sto	^{)p} *N	R2*
Sequence ID/ Work Center I	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		QC15- Crosstube Dimen	sional Check		0.00				- 0	- •		. •
130 QC Quality Control		Мето			0.00 5126	elix	•					
140					0.00					·		
140		Crosstubes										
Crosstubes Crosstubes		Memo 1-Drill Rive	t holes as per I	Owg D212-6	0.00 664-247 using DT8972.***	*Use T-Pin***						
		2-Drill pilot	holes in tube a	ıs per Dwg I	D212-664-247 using DT85	550 and DT8551	TW			120	2-2	(
		3-Ream hole	to finish size	in tube as p	er Dwg D212-664-247		•					
		4-Deburr & Dwg D212-6	Inspect for sur 664-247	face damage	e. Repair damage within li	imits as per			, ¬	5 7	١	
		5-Scribe part	# and hatch #	using vihra	ting stylus as ner Dwg D2	12-661 211			17.	- 2-2	_ 1	

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Work Order ID 79387 *79387* Page 3 January-25-12 11:51:33 AM Item ID: D212-664-207 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Crosstube Low Standard Aft **Start Date:** 25/01/2012 Start Oty: 1.00 **Cust Item ID: Required Date:** 08/02/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: _____ **Approvals:** Date: Tooling: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Otv **Qty** Number Stamp 150 Crosstubes Chemical Conversion 0.00 *150* HandFXtube 0.00 Memo 12-2-23 Hand Finishing Crosstubes Chemical Conversion Coat Tube & Cuffs 160 QC3- Inspect Part Finish 0.00 *160* 0.00 Memo

0.00

170

QC5- Inspect part completeness to step on W/O

*17**0***

Quality Control

Memo 0.00

Quality Control

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W/O:		WORK ORDER CHANGES											
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	Re	solution:	Dispositio	n:	_ QA: N/C CI	osed:	Date: _						
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF)		`					
	CTED	Description of NC		Corrective Action Section		Verification	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector					
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Work Ord				*793	387*							Page
Item ID: Revision ID:	D212-664-2			Accept	*N900	0040	110	N *	Setup		1.71	S1*
Item Name: Start Date: Required Date Reference:	25/01/2012	w Standard Aft Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:					Stop	*N	IS2*
Approvals:	Process Pla	an:	Date:	Tooling:		ate:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	ID .	Operation Description Outsource process - ND	F non OSI029 4 1	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp
180 Outsource2		Memo	. pei Q31036 4.1	0.00						D1.	202	27
Outsource process	- NDT	Issue P/O://	trant Inspection as per C LPI as per AS ch copy of NDT results	TM 1417								Ī/
190		Receive & Inspect for Da	mage & Mat'l Certs	0.00						1		_
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200

QC5- Inspect part completeness to step on W/O

200

Packaging

Memo

Quality Control

Inspect for damage & ensure results are as per Dwg D212-664-207

Ensure copy of NDT results attached to work order.

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W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	• <u></u>	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A :	Date:		
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Description of M					ion B	Verific	cation	Approval	Approval	
DATE			Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector	
 										

Work Order ID 79387 *79387* Page 5 January-25-12 11:51:33 AM Item ID: D212-664-207 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Crosstube Low Standard Aft **Start Date:** Start Qty: 1.00 25/01/2012 Cust Item ID: **Required Date:** 08/02/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: _____ Date: ____ Approvals: **Tooling:** Date: Stop QC: _____ Date:___ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Number Stamp **Qty** Otv 210 0.00 Crosstubes *210* Al 12 - 2-27 Crosstubes 0.00 Memo Crosstubes 1-Rivet and assemble Cuffs with T-Pin in the through bolt holes as per Dwg D212-664-247. with Sika flex in Between tube & Cuff A/R SIKAFLEX -241/-291 BATCH: 1199999 215

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

Inspect cuff with T-Pin

Q 12 1202.28

W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector		
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Part No		PAR #:	Fault Cate	egory:	NCF	R: Yes I	do DQ/	4 :	Date: _			
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DATE	STEP	Description of NC			ion B		Verific	ation	Approval	Approval		
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Work Order ID 79387 *79387* Page 6 January-25-12 11:51:33 AM D212-664-207 Item ID: Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Crosstube Low Standard Aft **Start Date:** 25/01/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 08/02/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run Start Process Plan: **Approvals:** Date: Tooling: Date: Stop Date:____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description Code **Run Hours** Qty Otv Number Stamp 220 Spray Painting per QSI005 4.2 0.00 SprayPaint *220* 12 - 2-28 SprayPaint 0.00 Memo Spray Painting 1-Prime inside and outside crosstube as per OSI 005 4.2 2-Paint outside crosstube with White Imron as per OSI 005 4.2 PRIME: Start Time: 10:14 Fininsh Time: 10:45 PAINT: Start Time: 3,00 Finish Time: 4:00

230

QC

QC14- Inspect Spray Paint

0.00

230

Memo

0.00

D 12 02.29

Quality Control

Wrap in plastic bag to protect from scratches

W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:	_ Date: _			
	R	esolution:	Disposit	ion:	QA: N/C Clo	sed:	Date: _			
NCR:		\	WORK OR	DER NON-CONFORMAI	NCE (NCR)					
DATE	STEP	Description of NC		Corrective Action Section		Verification		Approval		
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Work Order ID 79387 *79387* Page 7 January-25-12 11:51:33 AM D212-664-207 Item ID: Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Crosstube Low Standard Aft **Start Date:** 25/01/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 08/02/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: Approvals: Date: **Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code **Qty** Oty Number Stamp 240 0.00 Crosstubes *240* 12-2-29 Crosstubes 0.00 Memo Crosstubes 1- Assemble as per Dwg D212-664-247 1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe 2-Install supports with Proseal 890 per DSI9563 and QSI 015 A/R Proseal 890 Batch: 120072 3- Torque bolts as per dwg

250

QC5- Inspect part completeness to step on W/O

0.00

250

QC Quality Control

Memo

0.00

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W/O:		WORK ORDER CHANGES										
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Work Ord January-25-12				*793	87*							Page 8
Item ID: Revision ID:	D212-664-2	207		Accept	*N900	040	100)*	Setup	Start	*N	S1*
Item Name:	Crosstube Lo	w Standard Aft								Stop	*N!	S2*
Start Date:	25/01/2012	Start Qty: 1.00	*1*		Cust Item	ID:						
Required Date	e: 08/02/2012	Req'd Qty: 1.00	*1*		Customer:							
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Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:			Run	Start	*N	R1*
	QC:		Date:	_ SPC (Y/N):	D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Vannber	Insp. Stamp
255		Pick Kit		0.00					1	, /	/-)	~ ,
255								/	<i>1</i> 3	1,5		9
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Quality Control		Memo		0.00								
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Packaging		Memo		0.00					- (-		/3/3	-//

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Identify and pack for shipping as per PPP D212-664-207

Packaging

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DATE	STEP	PRO	CEDURE CH		Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Ord January-25-12				*79:	387*					Page 9
Item ID: Revision ID: Item Name:	D212-664-2 Crosstube Lo	07 w Standard Aft		Accept	*N900	<u>040</u>	100*	Setuj	p Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	25/01/2012 : 08/02/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				IV.7/
Approvals:	Process Pla	nn:	Date:	Tooling:	Da	ate:		Run	Start	*NR1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	*NR2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID		Plan Acc Code Qty		-	Reject Insp.
280		QC21- Final Inspection -	- Work Order Release	0.00				17	12/	1 X
QC		Memo		0.00				_16	121-	4-11)

Quality Control

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Work Order ID: 79387

79387

Parent Item: D212-664-207

D212-664-207

Parent Item Name: Crosstube Low Standard Aft

Start Date: 25/01/2012

Required Date: 08/02/2012

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 07.09.12 EC verified by: JLM

IPP Rev:B ECN 1100p 08-01-11 DD verified by: EC IPP Rev:C ECN 1121 08-02-25 DD verified by:eC

1	IPP Rev: D QC5 r	eplaced by QC15	at step	5 KJ Verifie	d by: ec								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-664- 207TRNRevA		Manufactured	No	786	<i>1</i> 7)	110	Each	0.0000	1 (1	mo	Du	12/2/13
*D212-664 Crosstube Turning Detail	4-207TF	RNRevA	*	70	141				**		/	Μ.,	
D3660-1		Manufactured	No			140	Each	4.0000	2	2			
*D3660-13	*								**				
				Location		<u>Loc</u>	<u>Oty</u>	Loc Code					
				ST482			4		_		_		
					53501 76260		1 3		_	(2)	- Au) /	2-2-21
CR3212-4-06		Purchased	No			220	Each	286.0000	44	44	,		
CR3212-	4-06								**	-	As	1プ-3	- 27
				Location		Logo	16.	Los Codo					

Location	Loc Qty	Loc Code	
ST331	286		
112492	18		
112794	8		
119717	203		44
120187	57		

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Parent Item: D212-664-207 Parent Item Name: Crosstube Low Standard Aft			9387*)212-664-2	07 *			•		
Parent Item Name: Crosstube Low Standard Aft		' '	,, ,, _,,,, ,, _,						
				(,,			tart Date: Start Qty:	25/01/2012 1.00	Required Date: 08/02/2012 Required Qty: 1.00
D3595-063-530 Manuf	actured	No		240	Each	79.0000	4	4	
D3595-063-530							**	-	AL 12-2-29
			Location	<u>Lo</u>	oc Oty	Loc Code			
			MAT052		79				_
			63407		6				_
			67185 70067		6				_
			72743		18 8			3	
			75783		41			2	_
D2940-1 Manufa	actured	No		240	Each	13.0000	2	2	_
D2940-1 Support							**		AS 12-2-29
			Location	Lo	c Oty	Loc Code			
			LG		3				
			76729		3				_
			LG052		10				_
N/021020 20			76729/		10			_ 2	-
MS21920-28 Purchas	sed	No		240	Each	59.0000	4	4	
M\$21920-28 Clamp(per MIL-DTL-8783C)							**		AB 12-2-29
			Location	Loc	e Oty	Loc Code			
			FG		5				_
			105884		5				_
			LG050		54				-
			116839		2				_
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DATE	STEP	Description of NC		Corrective Action Section			fication	Approval	Approval
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Work Order ID: 79387	- Address Anger	*7	9387*				·		
Parent Item: D212-664-207 Parent Item Name: Crosstube Low Star	ndard Aft		212-664-2	?07*		St	art Date	e: 25/01/2012	Required Date: 08/02/2012
						S	tart Qty	: 1.00	Required Qty: 1.00
D3428-1 *D3428-1* Placard	Manufactured	No		255	Each	25.0000	1 **	\$ P	(Se)
			Location ST042 76508 78933	<u>L</u> .	25 5 20	Loc Code			
MS21042L6 **MS21042L6* Nut	Purchased	No		255	Each	1,202.000	6 **	-6 SP	[Se]
			Location	<u>L</u> c	oc Oty	Loc Code			
			ST300		1202				
			117677 118384		25 3				
			118927		48				
			119075		926			6	
ANO CONTROL C			120308		200				
-AN960JD616 NAS1149D0663J *AN960.ID616* Washer	Purchased	No		255	Each	0.0000	18 **	(18) M119075	D SA
AN6-40A *AN6-40A* Bolt	Purchased	No		255	Each	124.0000	4 **	12/3/1	1 20
			Location	<u>Lo</u>	c Oty	Loc Code			
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes I	No DQA:	Date: _	
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Picklist Print

January-25-12 11:51:37 AM

Work Order ID: 79387

79387

Parent Item: D212-664-207 *D212-664-207*

Parent Item Name: Crosstube Low Standard Aft

Start Date: 25/01/2012

Required Date: 08/02/2012

Start Qty: 1.00

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Required Qty: 1.00

AN6-41A

Purchased

No

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Each

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Page 4

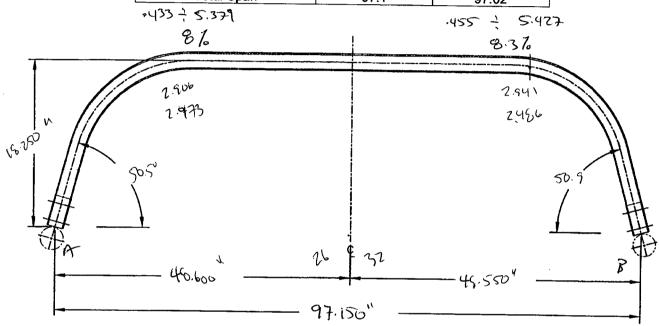
AN6-41A

Location Loc Qty Loc Code ST342 45 119749 20 120187 25

W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DART AEROSPACE LTD	Work Order:	79387
Description: Crosstube Low Aft (205/212)	Part Number:	D212-664-207
Inspection Dwg: D212-664-247 Rev: B		Page 1 of 1

Required Dimension	Min	Max
Height	18.16	18,42
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62



	Comments
Sinc	Az 8% crushin (W Z6 PASSES.
Sine	B2 8.3% (Mshy Q 32 PASSES
Sine	B2 8.36 (rush 0 32 passes
See	nute # 10.

QC15 Inspection	8
Date	12/07/17

Rev	Date	Change	Revised by	Approved
Α	08.02.29	New Issue	KJ/JM . A	7.55.00
В	10.04.01	Dwg Rev updated	KJ XA-	1

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item	Qty -247	Qty -247B	Part Number	Description
1	х		D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
2		Х	D212-664-247B	CROSSTUBE ASSEMBLY (209/212 LOW AFT)
3	1	1	D6008-132	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	_2	2	D3660-1	CUFF
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	_44	44	CR3212-4-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

D

1) MATERIAL: MANUFACTURED FROM D6008-132

FINISHED LENGTH = 128.268±0.020 (BEFORE BENDING/TRIMMING)

2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4.2

TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED. UNITS: INCHES UNLESS OTHERWISE NOTED.

BREAK SHARP EDGES: 0.005 TO 0.010 MAX.

IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.

WEIGHT D212-664-247 = 36.6 lbs (PER IIN-D212-664) D212-664-247B = 36.6 lbs (PER IIN-D212-664)

PART IS SYMMETRIC ABOUT CENTERLINE.

WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH

10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.

11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

12) INSTALL D2940-1 SUPPORTUSING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1

- SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.

 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005* MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

 16) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF
- SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 17) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

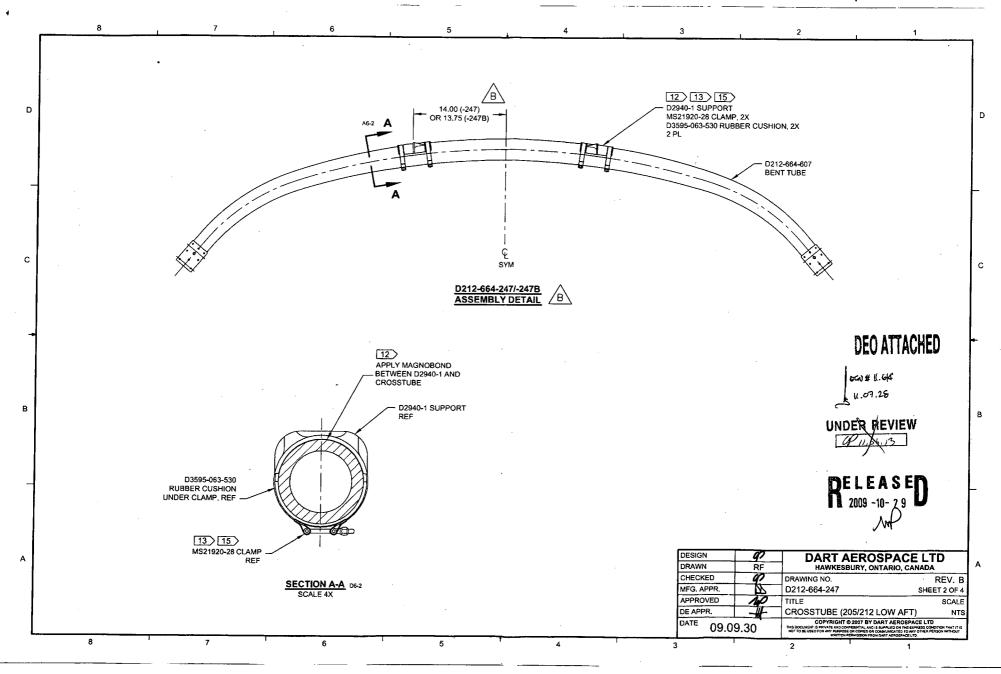
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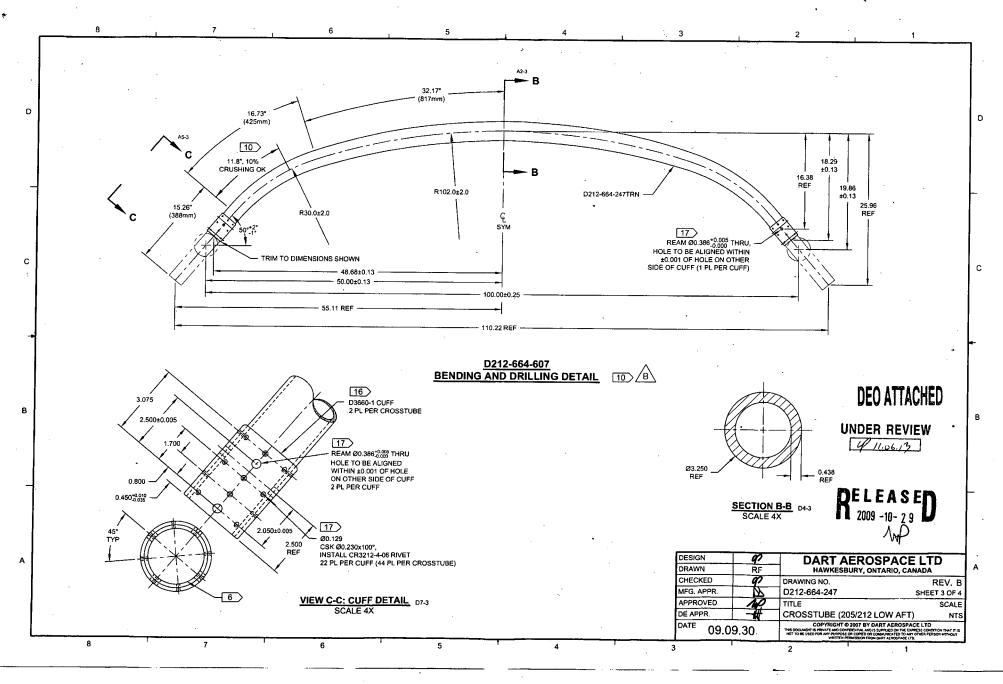
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В			NOTES/PART LIST; UPDATE TO RDS; ADD -247B (ZN C4-2, D5-2)	RF	09.09.30	
Α	NEW I	SSUE		CP	07.07.07	
REV.	1		DESCRIPTION	BY	DATE	
DESIGN P			DART AEROSP	ACE	LTD	
DRAWN	l	RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED P			DRAWING NO.		REV. B	
MFG. AI	MFG. APPR.		D212-664-247 SHEET 1 O			
APPROVED 10		10	TITLE		SCALE	
DE APPR.			CROSSTUBE (205/212 LOW AFT) NTS			
DATE	09.0	9.30	COPYRIGHT © 2007 BY DART AEROSPACE LTD PES DOCUMENT DAY DE MONAT AND DOMBOTH AND AS SEPTING OF THE DOMESS CONDITION THAT IT IS NOT TO BE USED FOR AN INTELL PERSONS OF THE MONATOR AS OFFICE AND THE PERSON WITHOUT APPROXIMATION DAYS AS OFFICE AND THE PERSON WITHOUT APPROXIMATIO			

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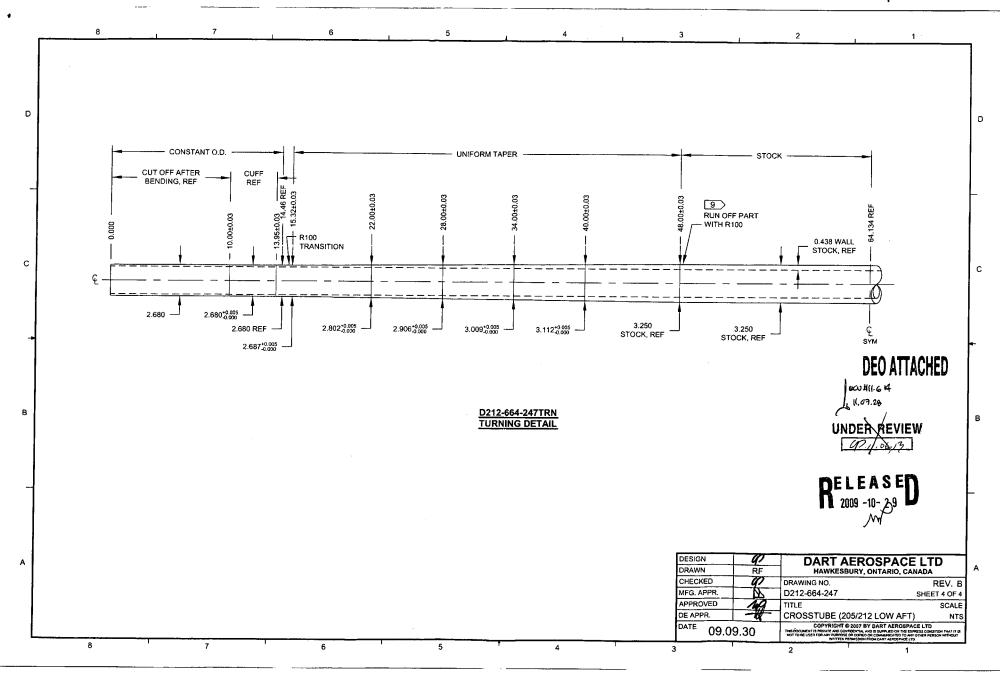


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Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification **Description of NC Approval Approval** DATE **STEP** Sign & **Action Description** Initial Section A QC Inspector Section C Chief Eng Chief Eng Date Chief Eng

JA387

DRAWING NO D212-664-		TITLE CROSSTUBE ASS'Y (20	REV. B LOW AFT)	DART AEROSPACE LT ENGINEERING ORDER		SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN	P	CHECKED	A>5	MFG. APPR.	APPROVED (M)	DE APPR.	NIS
DATE	11.07.1	5DATE //,	27.70	DATE 11.07.21	DATE 11/07/2)	DATE 11.07.21	

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	em Qty Qty Part Number -247 -247B		Part Number	Description		
9	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2		

WAS:

9 A/R A/R MAGNOBOND 6398 ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)				; · · · · · · · · · · · · · · · · · · ·	
	9	A/R	A/R	MAGNOBOND 6398	ADHESIVE (TEXTRON/BELL SPEC. 299-947-100,

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2940-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.



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ITEM(S) EXAMINED	(8) -	CESS TOES		
las December			7	Total
JOB DESCRIPTION	PROCEDURE No. LT	REV./DATE	que No. LT/642 Rev./C	DATE 2003
PART NO.	SEE CESULES	MATERIAL ALLE /	than men THICKNESS	VALCOUS
SCOPE A WET	Phoenescent	LI OU. D PENERILA	NT INSPECT	er JAj
-NO IR		FORTEWAL DIS		
TEST DETAILS			mat.n.mot.	
METHOD	☑ FLUORESCENT ☐ VISIBL	LE WATER WASH	☐ SOLVENT REMOVABLE	☐ Post Emulsified
FAMILY BRAND	NATUR	BLACK LIGHT S/N / 643	🥱 🗆 ОUТРИТ > 1000 µ W/CM	
PENETRANT ZL			HLIGHT 🗆 TROUBLELIGHT 🔲 O	00 fc @ SURFACE
PENETRANT REMOVER	 		NO CO	Due Date
DEVELOPER TYPE		IO MIN. LIGHT METER S/N / O	, , , , , , , , , , , , , , , , , , , ,	DUE DATE
TEST SURFACE	NON AQUEUGS A AQUEUGS	DIXI		and the state of
	As Ground	☐ MACHINED ☐ SI	HOT BLASTED	CLEAN BARE METAL
SURFACE TEMPERATURE) > 52°C/125°F
RESULTS- (2	METRIC IMPERIAL)			
that all descriptions, comments and exp representations or warranties. Acuren C data or other information provided by A Standard of Care	perform services extends only to those services provided for existing of point on reflect the opinions or observations of a froup Inc. is not assuming any responsibilities of the owner curve Group Inc. In no event shall Acuren Group Inc.'s lie.	Acuren Group Inc. based on information and assumption: r/operator and the owner/operator retains complete resp ibility in respect of the services referred to herein exceed	supplied by the owner/operator and are not onsibility for the engineering, manufacture, v the amount paid for such services.	intended nor can they be construed as pairfund use decisions as a result of t
In performing the services provided. Accordinglied, is made or intended by Actoren SIGNATURES	tren Group Inc. uses the degree, care and skill ordinarily e Group Inc.	exercised under similar circumstances by others performi	ng such services in the same or similar local.	ty. No other warranty, expressed or
CLIENT REPRESENTATIVE	Andrew Sheldon	Alpha	DTR# €	63814
TECHNICIAN (SIGNATURE):	BBIN	SIGNATÜRE	REPORT REVIEWED BY:	
NAME (PRINT):	- West Ston		NAME	INITIALS
	CGSB LEVEL SNT LEVEL	2 ¹⁶ TECHNICIAN CGSB LEVEL SNT LEVEL CGSB REG. NO		